

September 29, 2009 2:44:17 PM



Accept

**Setup Start**

A

Stop

**Cust Item ID:**

Customer:

Reference:

Approvals:

Process Plan:

Dates

Tooling:

Date:

Run Start



QC:




Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3043	Rev A								
100 	Large Fab	0.00				4	0		
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G□2-Debur and bevel ends for welding				09.10.02				
110 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120 	Large Fab	0.00				4	0		
Large Fab	Memo	0.00							
Large Fab	1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808□AR AL ROD Batch: <u>m111311</u> □2-Grind Fwd End Cap weld flush <u>m111494</u>				09.10.13				

Work Order ID 52537

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Page 2

Item ID: D3043-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Step Weldment RH, A119

Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.10.13

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8 or 10 / 13

x4 RH

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H 09.10.13

42



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Page 3

Item ID: D3043-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Step Weldment RH, A119
Start Date: 29/09/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 16/10/2009 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Large Fab	Large Fab	0.00				4	0		
Large Fab	Memo 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR ALROD Batch: <u>M111311</u> □2-Inspect for foreign object as per QSI024□3-Grind Fwd End Cap weld flush	0.00							
170  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

Work Order ID 52537

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Item ID:	D3043-042	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Step Weldment RH, A119					
Start Date:	29/09/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	16/10/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	09-10-19			④			
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MO 09/10/19			X4			
210 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 112200 Memo START TIME: 11:45 300° □ FINISH TIME 12:15	0.00 0.00	09-11-19			④			

□ OVEN TEMPERATURE:

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Accept

Revision ID: A

Item Name: Step Weldment RH, A119

Start Date: 29/09/2009 **Start Qty:** 4.00

Required Date: 16/10/2009 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220

~~Pressure Wash per OST005 4.3~~

0.00

Draw Number	Draw Rev.	Plan Code
----------------	--------------	--------------

Accept Qty	Reject Qty
------------	------------

Reject Number	Insp. Stamp
------------------	----------------

HandFinish

Hand Finishing

Wing Walk ASP-055005
S Memo

~~SL 09-10-11 MD 09/10/20~~

xy ~~z~~g

230

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

09/10/20

x4 ~~0~~

240

Identify as per dwg & Stock Location: PTM

0.00

[illegible]

Packaging

Packaging

Memo

0.00

tion: PDP
52520

Page 10 of 21

Picklist Print

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Page 1

Work Order ID: 52537

Parent Item: D3043-042RevA

Parent Item Name: Step Weldment RH, A119



Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Row Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3040-3RevB		Manufactured	No			100	Each	54.0000	8.0000			
												
Mounting Lug												

12 09.10.02

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	<u>3</u>	
<u>42945</u>	3	
Main Warehouse		
WA	51	
<u>48240</u>	51	

D2622-120CRevC1

Manufactured No



Step Extrusion

120 Each 185.9200 4.0000



12 09.10.02

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	185.92	
<u>48612</u>	73.92	
<u>52026</u>	112	

4

D2734RevC

Manufactured No



Step End Plate

120 Each 81.0000 8.0000



12 09.10.02

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	81	
<u>43535</u>	2	
<u>48110</u>	79	

4

Picklist Print

Page 2

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Work Order ID: 52537



Parent Item: D3043-042RevA



Parent Item Name: Step Weldment RH, A119



Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3040-1RevB  Mounting Lug		Manufactured	No			120	Each	56.0000	8.0000 		<i>09.10.02</i>	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

42944 = 1

1

Main Warehouse

WA

55

48239 = 7

55



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DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 52537

PL 099-29

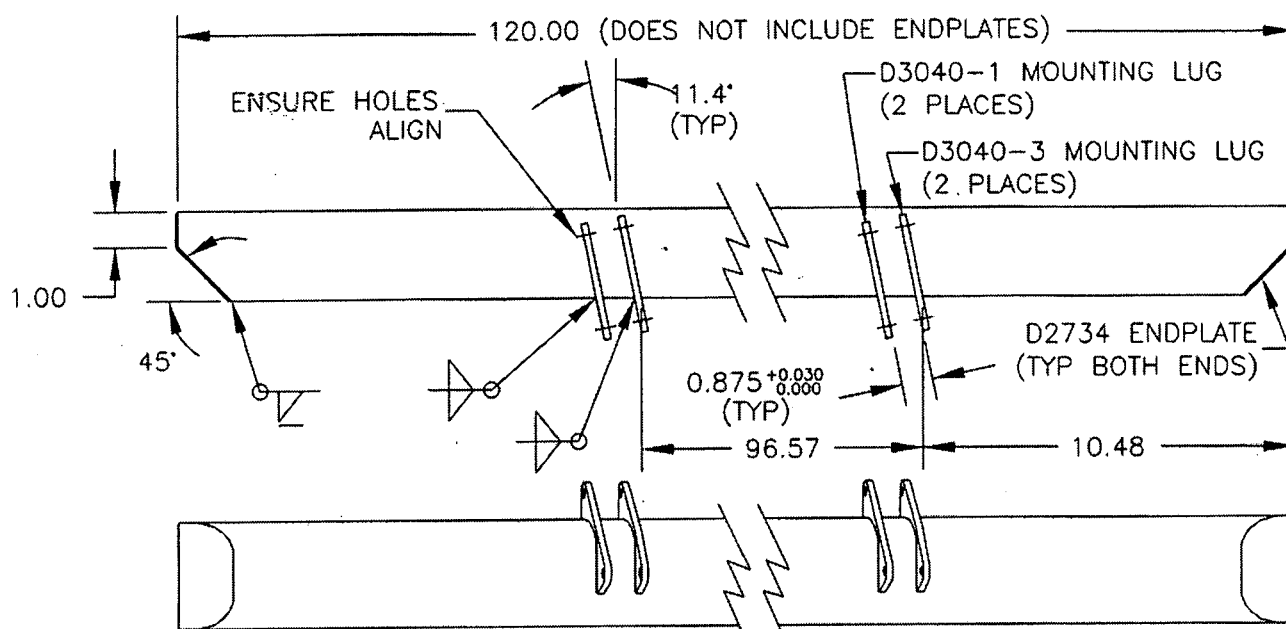
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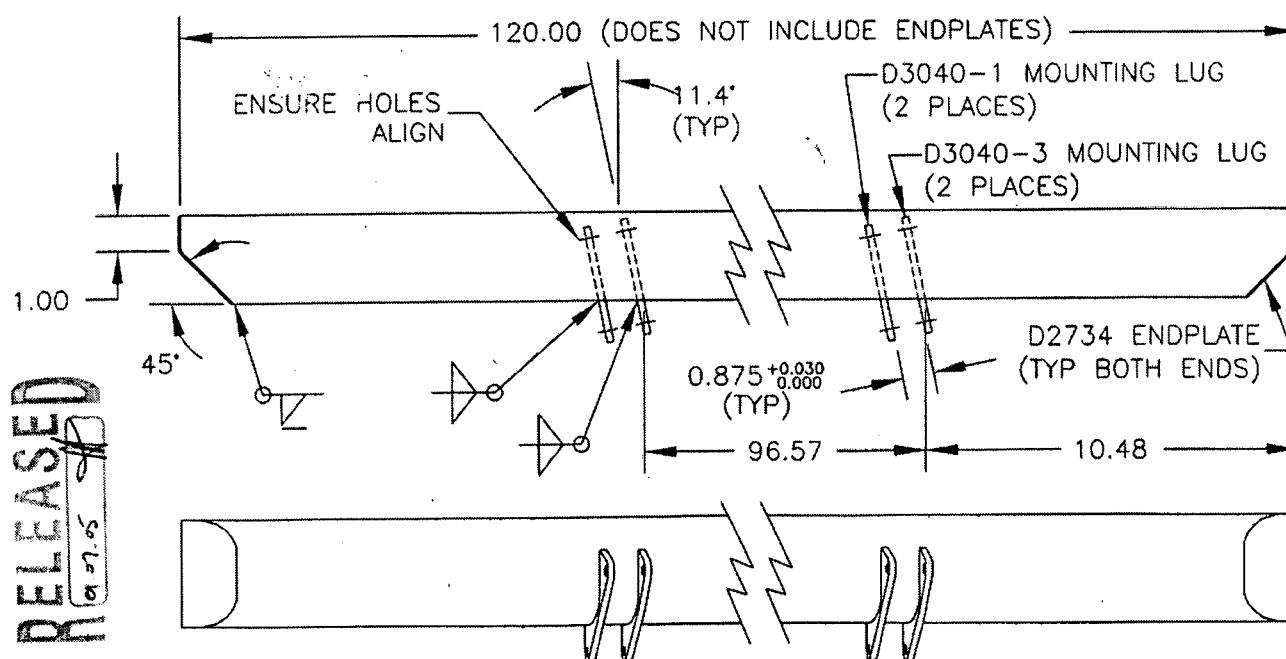
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CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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